

Date: Monday, 1/7/2008 3:38:21 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206  
 Job Number : 36627  
 Estimate Number : 10821  
 P.O. Number :  
 This Issue : 1/7/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D26662  
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2666 REV.D  
 Previous Run : 34781 Project Number : N/A  
 Material : D  
 Due Date : 1/31/2008 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : JA 08.01.08  
 Comment : Est: C 00.11.01 , Removed P/O for Powder Coat - in house  
 processEC  
 Est Rev:D As per Rev D 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 2X6X6.25  
 Issue material from stock:  
 Cut Size 2.0 x 6.25 X 6.0  
 Grain Along Long 6.0 Length  
 DIP 08/04/22 Batch No: B34643

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 3-Fixturing Inspection last completed on 08/04/22 by DIP  
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 7- Deburr  
 DIP 08/04/22

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet  
 DIP 08/04/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
 DIP 08/04/24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:21 PM  
User: Kim Johnston

## Process Sheet

30 min

29/04/2008

S.137 08.00

#1 318.7 F

#2 026662. F

#3 B36627 F

#4 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 36627

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/04/25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/04/28

Counted  
12 X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/07550

FL 08/04/29

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-01-29

(112)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57426

08/04/29

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30

Job Completion



MF 08-04-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	36627
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.117	0.117	.118	.118		
B	0.100	0.140		0.1115	0.112	0.111	.109		
C	2.470	2.510		2.500	2.505	2.505	2.505		
D	0.100	0.180		0.165	.166	.167	.162		
E	0.210	0.230		0.220	0.220	0.220	.219		
F	1.313	1.343		1.325	1.323	1.323	1.322		
G	0.240	0.260		0.248	.250	.251	.253		
H	0.615	0.685		0.646	0.646	0.646	.656		
I	1.125	1.145		1.1345	1.135	1.135	1.135		
J	0.990	1.010		0.995	.998	.999	.999		
K	0.235	0.240		.235	.235	.235	.235		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		0.112	.115	.110	.112		
N	1.565	1.585		1.579	1.579	1.579	1.579		
O	5.990	6.010		6.003	6.001	6.002	6.004		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		0.496	.505	.500	.501		
S	0.313	0.318		0.3145	.313	.313	.313		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.362	1.362	1.362		
V	0.315	0.322		0.322	0.322	0.322	.322		
W	0.540	0.560		0.546	0.546	.546	.546		
X	1.674	1.684		1.677	1.678	1.679	1.678		
Y	0.257	0.262		0.259	0.259	0.259	.258		
Z	0.178	0.198		0.187	0.187	0.187	.187		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DTP / R.F.	Audited by: SA
Date: 08/04/23 / 08/04/24	Date: 08/04/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	36627
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	54	63	73	84	By	Date
A	0.100	0.140		.114	.115	.115	.120		
B	0.100	0.140		.122	.122	.122	.122		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.164	.164	.176	.164		
E	0.210	0.230		.224	.220	.218	.218		
F	1.313	1.343		1.323	1.322	1.322	1.322		
G	0.240	0.260		.246	.242	.250	.251		
H	0.615	0.685		.656	.656	.656	.656		
I	1.125	1.145		1.135	1.144	1.134	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.235	.235	.235	.235		
L	0.510	0.515		.510	.510	.519	.510		
M	0.100	0.120		.112	.114	.125	.125		
N	1.565	1.585		1.575	1.582	1.578	1.576		
O	5.990	6.010		6.002	6.002	6.003	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.501	.501		
S	0.313	0.318		.313	.313	.313	.313		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.366	1.367	1.367	1.367		
V	0.315	0.322		.322	.322	.322	.322		
W	0.540	0.560		.550	.550	.549	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	S.F.
Date:	08/04/24

Audited by:	SD
Date:	08/04/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 36627
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.100	0.140		.115	.115	.115	.115		
B	0.100	0.140		.119	.119	.119	.119		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.165	.165	.165	.165		
E	0.210	0.230		.218	.220	.220	.220		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.250	.250	.250	.250		
H	0.615	0.685		.665	.665	.665	.665		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.230	.230	.230	.235		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.112	.112	.112	.112		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.505	.500	.500	.500		
S	0.313	0.318		.313	.313	.313	.313		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>RF</i>
Date: 08/04/24-25

Audited by: <i>SA</i>
Date: 08/04/25

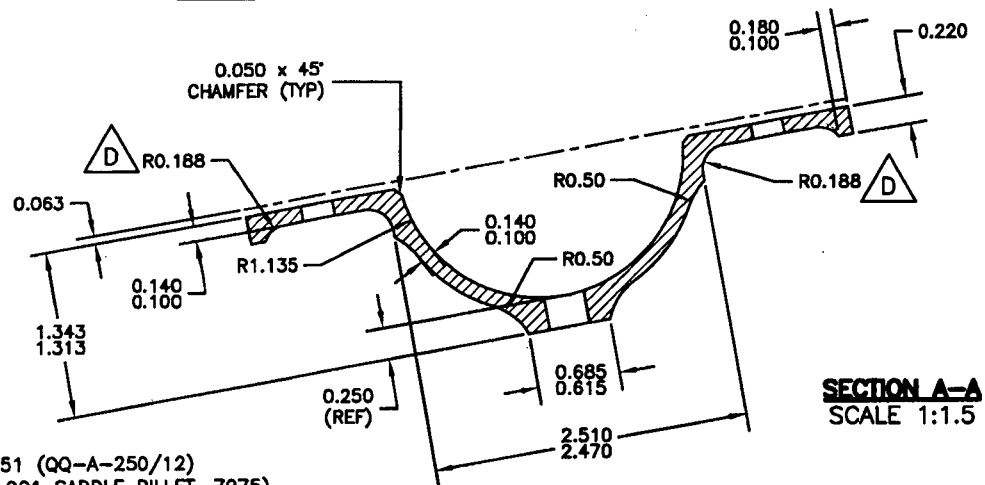
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

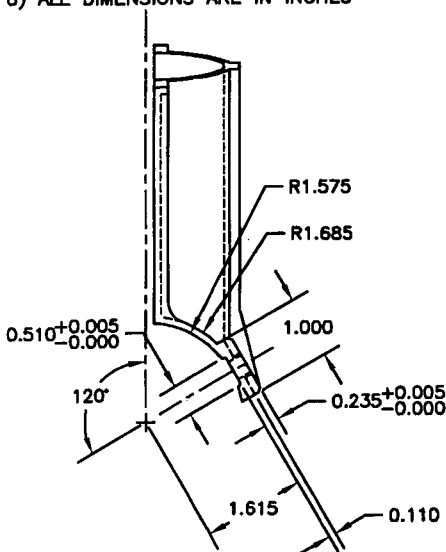
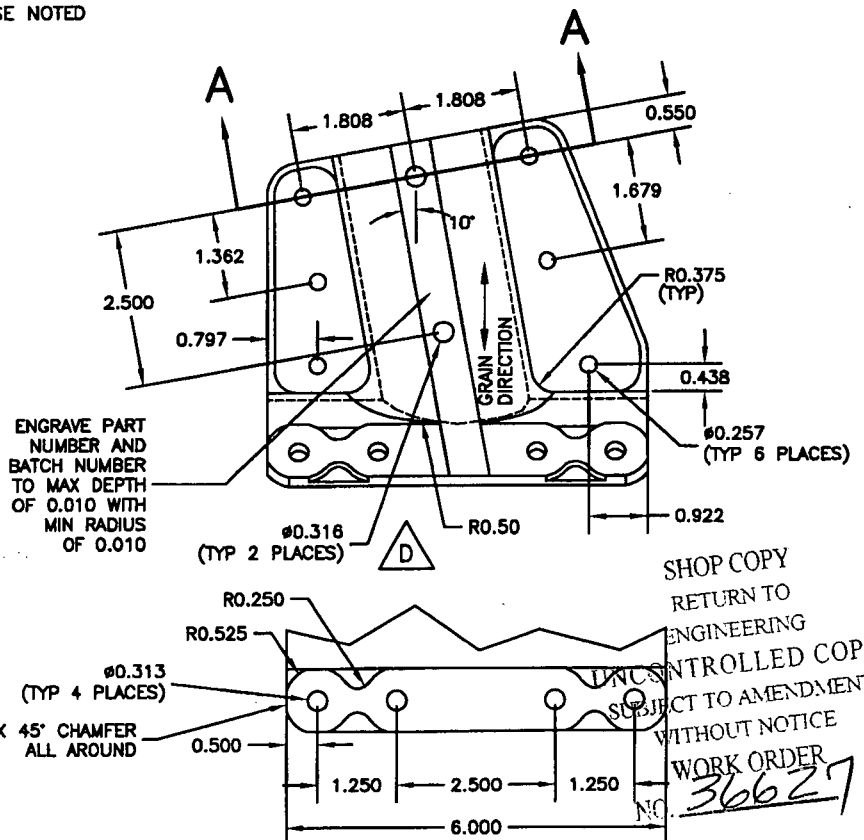
RELEASED

07.02.12 [Signature]



## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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